

Work Order ID 59108

Wednesday, May 26, 2010 1:21:57 PM



Page 1

Item ID: D2274

Accept



Setup Start



Revision ID:

Item Name: Radius Block

Stop



Start Date: 5/26/2010 Start Qty: 220.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 220.00



Customer:

Reference:

Approvals:

Process Plan:

M

Date: 10-5-24

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2274	Rev F								
100		0.00							
	SHEAR								
Shear	Memo	0.00							
Shear	blanks 9.00" long +/- 0.030" □ Note: 1 blank makes 9 pieces								
110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per folio D2274								
120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

Carl 10/06/02

220

88 10/06/03

Carl 10/06/02

220

Carl 10/06/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 6/4/2010 Req'd Qty: 220.00

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Cust Item ID:

Customer:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

*10-6-4**220*

QC

Memo

0.00

Quality Control

140

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Tumble ☐ Deburr any rough edges after tumbling*B 10-6-8*

150

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

220 B 10-6-8

W/O:		WORK ORDER CHANGES					
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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 010

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control



Setup Start



Stop



10/06/08

220

0

x220

BB

10/06/09

10/06/09

mf
10-6-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Wednesday, May 26, 2010 1:22:03 PM

Page 1

Work Order ID: 59108



Parent Item: D2274



Parent Item Name: Radius Block

Start Date: 5/26/2010

Required Date: 6/4/2010

Comments: IPP H00.05.18 Added inspection level 8 EC

Start Qty: 220.00

Required Qty: 220.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B00750X00.1 25		Purchased	No			100	f	120.5147	0.0916	21.21263			



6061-T6 Bar .750 x .125



Location	Loc Qty	Loc Code
MAT01	120.5147	
113608	79.6	
113680	1.4947	
→ 113719	39.42	

22' *and 10/06/01*

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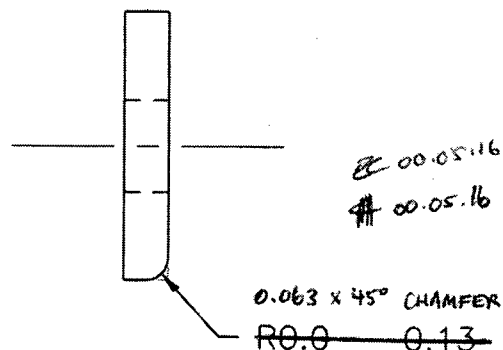
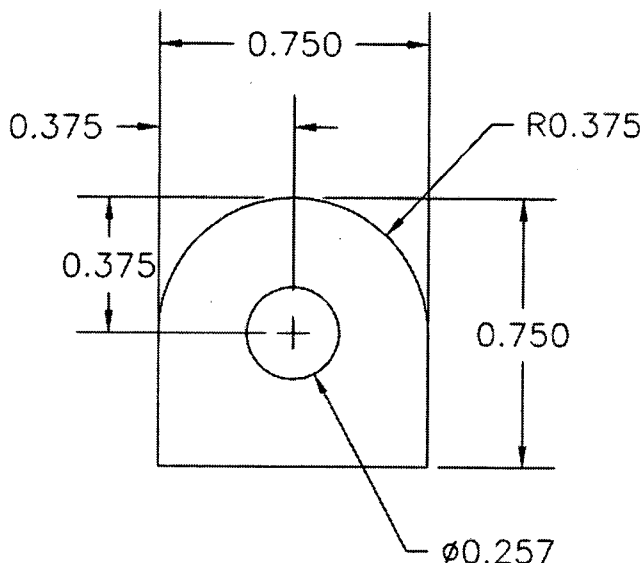


RELEASED
98/08/18 KE

DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11		TITLE RADIUS BLOCK	SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59105

105-20



MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
OR 6061-T6 (QQ-A-250/11) 0.125 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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